

5106

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22181</b>
<b>Description:</b> Hinge Bracket	<b>Part Number:</b>	<b>D2857-2</b>
<b>Drawing:</b> D2857 Rev. A1	<b>Qty:</b>	<b>24</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	HA	05.01.14	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch <u>M16615</u>	SD	05.02.09	24
3	HAAS	Machine per folio D2857-2	EC	05.02.16	24
4	QC	Inspect Level 2	EC	05.02.16	24
5	METAL	Tumble Deburr any rough edges after tumbling	EC	05.02.16	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	ML	05.03.21	24
7	QC	Inspect Level 7	2	05.03.21	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	ML	05.03.22	24
9	QC	Inspect Level 3	ML	05.03.22	24
10	STORES	Identify and stock	CD	05.03.24	24
11	EXPEDITING	Close W/O Cost / Part: <u>27.20</u> <u>540</u> <u>05/03/24</u> <u>(24)</u> <u>18.39</u>	HA	05.04.05	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

**RELEASED**  
JUN 26 2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order: 22181
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857	Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.304				
0.340	+/-0.010	0.344				
1.110	+/-0.005	1.112				
1.790	+/-0.010	1.792				
1.320	+/-0.005	1.321				
2.000	+/-0.010	2.006				
Ø0.171	+0.005/-0.000	Ø0.171				
0.147	+/-0.010	0.139				
0.376	+/-0.010	0.368				
0.126	+/-0.010	0.129				
0.611	+/-0.010	0.612				
0.063	+/-0.010	0.062				
0.166	+0.005/-0.000	Ø0.166				
0.911	+/-0.010	0.907				
0.600	+/-0.010	0.609				
0.125	+/-0.010	0.127				
0.150	+/-0.010	0.146				

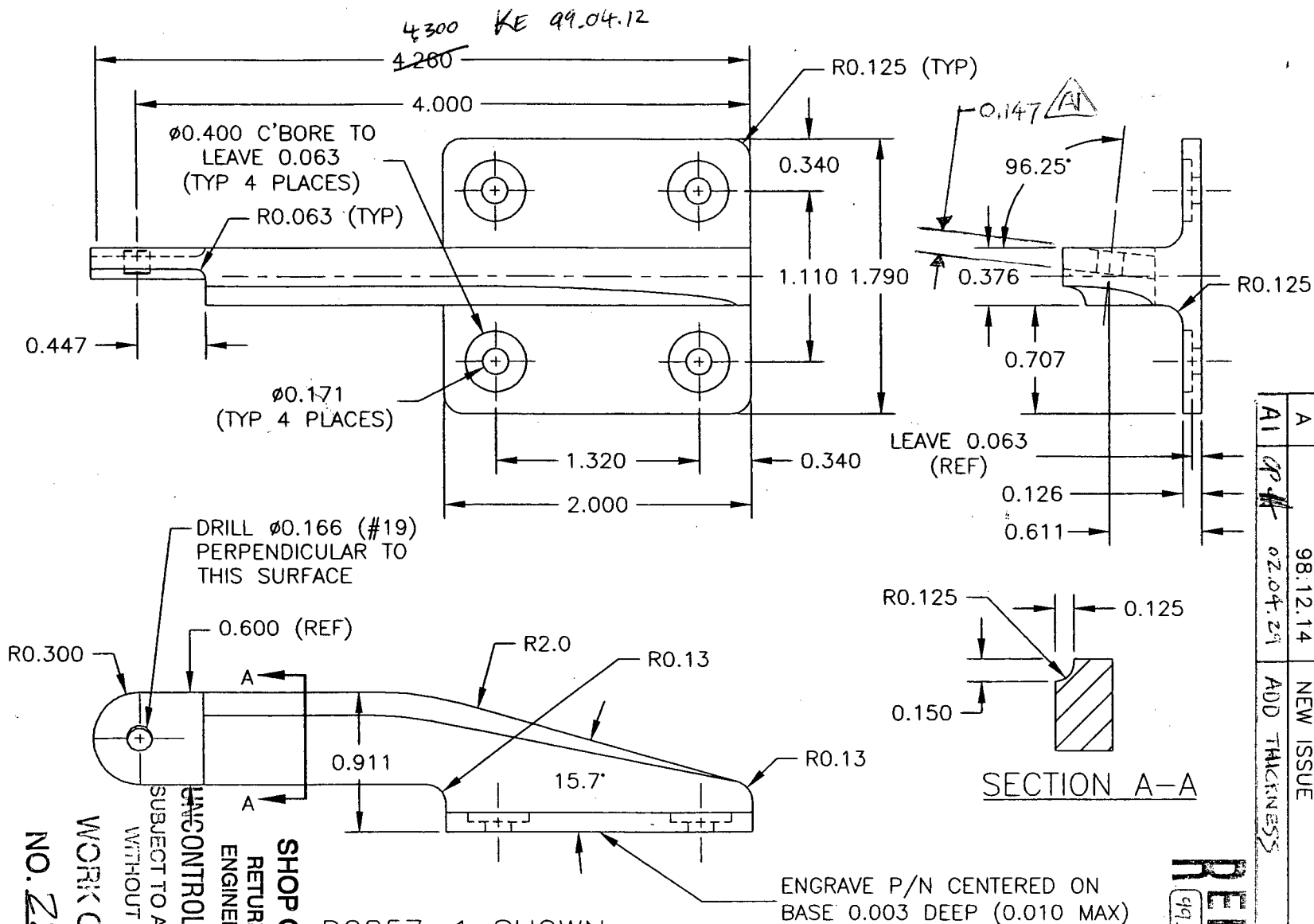
Measured by: <i>EC</i>	Audited by: <i>TRG</i>	Prototype Approval:	N/A
Date: 05.02.15	Date: 05/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED  
05/04/07



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED KE	APPROVED JF	DRAWING NO. D2857	REV. A	
DATE 98.12.14		TITLE HINGE BRACKET	SHEET 1 OF 1	SCALE 1:1
A	98.12.14	NEW ISSUE		
A1	02.04.29	ADD THICKNESS		



D2857-1 SHOWN  
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
99.01.06 KE

WORK ORDER  
NO. 22181  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
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ENGINEERING

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 12, 2005  
01:18 pm

Work Order No : 0022181  
Project Name : D2857-2  
Project For : WK506  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2857-2  
Description : Hinge Bracket  
Manufactured : Yes  
Amount Req'd : 24  
Amount Done : 0  
Start Date : 01-12-05  
Est Finish Date : 02-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00